

Work Order ID 128009

December-22-14 10:52:39 AM

slip Jan 9

128009

Page 1

Item ID: D4101-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step

Start Date: 12/18/14 Start Qty: 15.00

15

Cust Item ID:

Required Date: 12/22/14 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4101

B

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

3.85" LONG

9

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DAS
44
9-89

15-01-05

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per dwg and Folio FA946

DEBURR

9

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DAS
20
9-89

15-01-07

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

9

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DAS
20
9-89

15-01-07

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Page 2

Item ID: D4101-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step
 Start Date: 12/18/14 Start Qty: 15.00 *15* Cust Item ID:
 Required Date: 12/22/14 Req'd Qty: 15.00 *15* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 08 9-89
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							DAS 38 9-89
150									
QC	Memo	0.00							
Quality Control									

JAN 15 2015

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Item ID: D4101-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step
 Start Date: 12/18/14 Start Qty: 15.00 *15* Cust Item ID:
 Required Date: 12/22/14 Req'd Qty: 15.00 *15* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 708	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

9 JAN 19 2015 DAS CG 9-89

15/1/19

15-1-19

Picklist Print

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Page 1

Work Order ID: 128009

128009

Parent Item: D4101-3

D4101-3

Parent Item Name: Step

Start Date: 12/18/14

Required Date: 12/22/14

Start Qty: 15.00

Required Qty: 15.00

Comments: EST REV:A NEW ISSUE

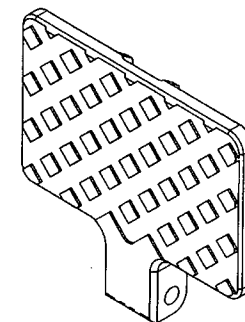
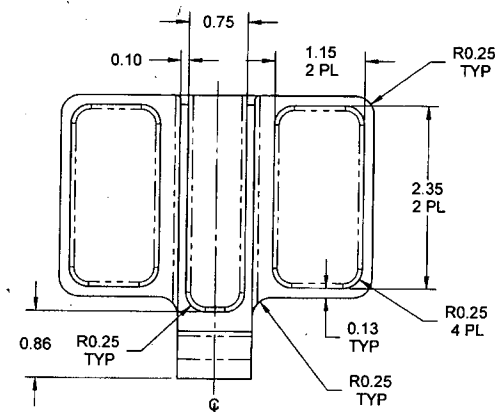
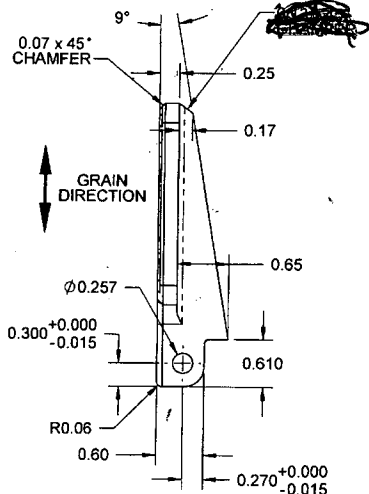
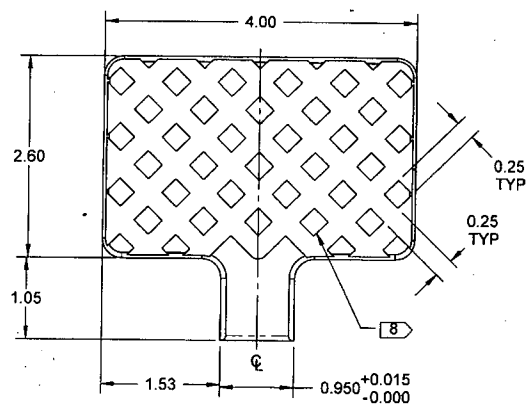
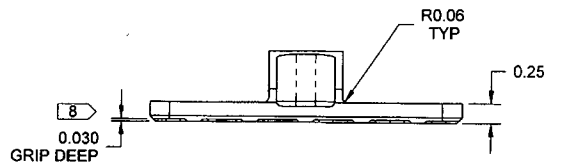
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No			100	f	6.1500	0.33	5.210526			
										**			
										DAS			
										44			
										9-89			
										15/01/05			

M6061T6B1 250X04 500

6061-T6 Bar 1.25 X 4.50

Location	Loc Qty	Loc Code
MAT004	6.15	
M126160	4	
M128866	2.15	

4
2.15



D4101-3 STEP

RELEASED
2010-08-23

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) MACHINE 0.25 x 0.25 GRIP 0.030 DEEP AT 45° PATTERN 0.25 APART

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4101	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PRE-FLIGHT STEP ASSEMBLY	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 128 009
Description: Step		Part Number: D4101-3
Inspection Dwg: D4101	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R.06	+/- .030	.062	✓		Rad gauge	
.25	+/- .030	.247	✓		SLO8	Vein
.030	+/- .010	.030	✓			
4.00	+/- .030	4.000	✓			
2.60	+/- .030	2.596	✓			
1.05	+/- .030	1.050	✓		Height gauge	
1.53	+/- .030	1.521	✓		Height gauge	
.950	+ .015 / - 0.000	.956	✓			
.25	+/- .030	.250	✓			
.25	+/- .030	.250	✓			
.13 X 45°	+/- .030 X 45°					
9°	+/- .5°	9°	✓			
.07 X 45°	+/- .030 X .5°	.070 X 45°	✓			
.25	+/- .030	.247	✓			
.17	+/- .030	.165	✓			
.65	+/- .030	.655	✓			
.610	+/- .010	.611	✓			
.270	+ .000 / - .015	.259	✓			
.60	+/- .030	.592	✓			
R.06	+/- .030	.060	✓		Rad gauge	
.300	+ .000 / - .015	.2945	✓		↓	
.257	+ .005 / - .001	.258	✓		gauge Pin	
.07						

DAS

Measured by: 20 9-89	Audited by: J.A DAS 08	Preliminary Approval:
Date: 15-01-06	Date: 15/01/08 9-89	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

